

Work Order ID 68358

Tuesday, April 12, 2011 10:11:11 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *HP*

Date: 11-04-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3535 | Rev B |

100



FLOW WATER JET

Waterjet

Memo

0.00

11-4-19

FLOW CNC Waterjet

*304 . 644*I-Cut as per Dwg D3535 Dwg Rev: *R* Prog Rev: *S* 2-
Deburr if necessary*78*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

11-4-19

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

11-4-19

QC

Memo

0.00

Quality Control

x7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68358

Tuesday, April 12, 2011 10:11:12 AM



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Item ID: D3535-15

Accept



Setup Start

**Revision ID:****Item Name:** Wearshoe

Stop

**Start Date:** 4/12/2011 **Start Qty:** 6.00**Cust Item ID:****Required Date:** 4/15/2011 **Req'd Qty:** 6.00**Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:**

Run

Start

**QC:****Date:****SPC (Y/N):****Date:**

Stop

**Sequence ID/
Work Center ID**

130



Brake NC

**Operation
Description**

NC BRAKE

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Brake NC

Brake NC

Memo

0.00

JB 11/04/19

(7X)

=7 M-1 11/04/20

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 11/04/20

(X)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

10:10

OVEN TEMPERATURE:**FINISH TIME:**

320°

10:40

7 BL 11-4-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68358

Tuesday, April 12, 2011 10:11:12 AM



Page 3

Item ID: D3535-15

Accept



Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

QC3- Inspect Part Finish

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

7 4 11-04-25

0.00

11-04-25

170



Packaging

Identify as per dwg & Stock Location *FPY8*

0.00

7 11-11-25

0.00

Packaging

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11-04-25

Quality Control

11-04-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:11:18 AM

Page 1

Work Order ID: 68358



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA | | Purchased | | No | | 100 | sf | 67.4000 | 1.0205 | 6.445263 | 7.2 | | |

304/316 .040 Sheet



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT020 | 67.4 | |
| 116437 | 25.4 | |
| 116623 | 42 | 116623 |

(7b)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------|--------|--------------|-------------|
| DART AEROSPACE LTD | | Work Order: | 68358 |
| Description: Wearshoe | | Part Number: | D3535-15 |
| Inspection Dwg: D3535 | Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.885 | +/-0.010 | 1.888 | > | | V ISO2 | |
| 2.000 | +/-0.010 | 2.000 | < | | V | |
| 5.650 | +/-0.010 | 5.656 | < | | T ISO1 | |
| 9.150 | +/-0.010 | 9.150 | < | | T | |
| 14.400 | +/-0.010 | 14.400 | > | | T | |
| 19.650 | +/-0.010 | 19.656 | > | | T | |
| 24.900 | +/-0.010 | 24.900 | < | | T | |
| 30.150 | +/-0.010 | 30.156 | > | | T | |
| 33.650 | +/-0.010 | 33.650 | > | | T | |
| 35.650 | +/-0.010 | 35.656 | < | | T | |
| 39.150 | +/-0.010 | 39.150 | < | | T | |
| Ø0.188 | +0.005/-0.001 | .191 | < | | V | |
| 24.00 | +/-0.030 | 24.00 | > | | T | |
| 16.00 | +/-0.030 | 16.00 | < | | T | |
| 8.00 | +/-0.030 | 8.00 | < | | T | |
| 5.00 | +/-0.030 | 5.00 | < | | T | |
| 0.300 | +/-0.010 | .302 | < | | J | |
| 0.300 | +/-0.010 | .305 | > | | V | |
| 0.038 | +/-0.010 | .035 | < | | V | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | RB | Audited by: | J | Prototype Approval: | N/A |
| Date: | 11-4-19 | Date: | 11/04/19 | Date: | N/A |

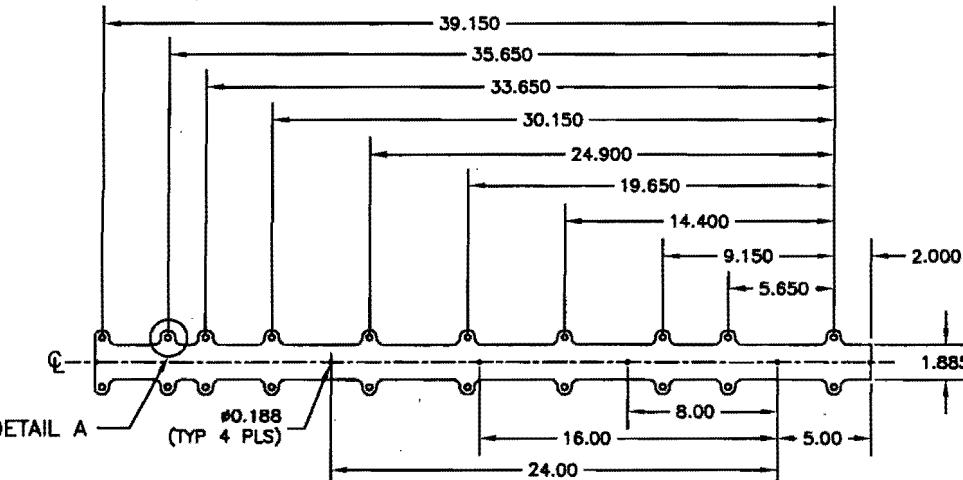
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.05.10 | New Issue | KJ/JLM | EE |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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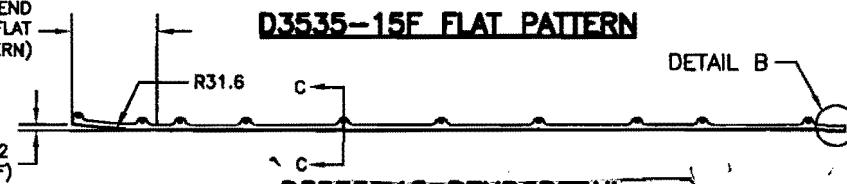
NOTE: Date & initial all entries



D3535-15F FLAT PATTERN

4.50 TO BEND
LINE (ON FLAT
PATTERN)

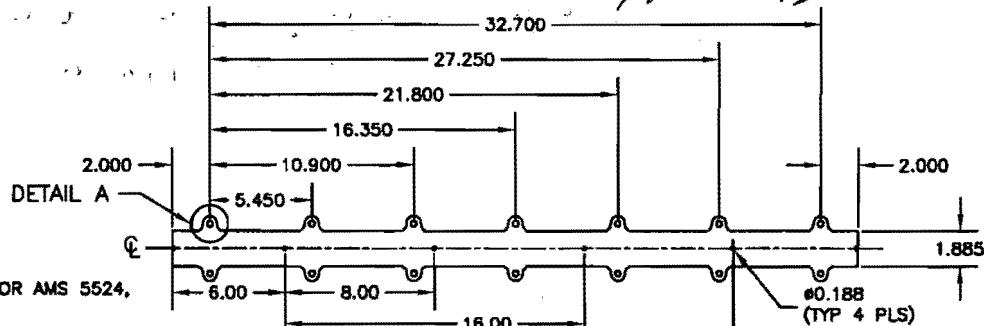
0.32
(REF)



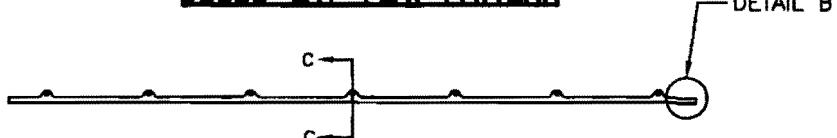
D3535-15 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28358

RELEASED
67.04.24



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | PORT HADLOCK, WA | REV. B |
|----------|----------|--------------------------|------------------|--------------|
| CB | MM | | | |
| CHECKED | | APPROVED | DRAWING NO. | |
| | | MM | D-3535 | |
| DATE | | | TITLE | |
| 07.04.17 | | | WEARSHOE | |
| | | | | SCALE |
| | | | | 1:10 |
| | | | | SHEET 2 OF 7 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries